



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

ASAP

D2873-043
Job Sheet 173681



Part No: D2873-043

Job Qty: 50 ea

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		3/15/18	0.00	0.00	Start Up Machining-1		SBL 18/03/12
100	Bandsaw	50 pcs		3/15/18	0.00	0.24	Bandsaw1		SBL 18/03/12
110	CNC Vertical Machining	50 pcs		3/15/18	0.04	13.19	HAAS1-2		SBL 18/03/12
120	QC	50 pcs		3/15/18	0.00	0.00	QC2 Machining-1		SBL 18/03/12
130	QC	50 pcs		3/15/18	0.00	0.00	QC8 Machining-1		MAR 18/03/13
150	QC	50 pcs		3/15/18	0.00	0.00	QC5		38
160	HandFinish	50 pcs		3/15/18	0.00	0.63	HandFinish1		SA 18-3-13
170	QC	50 pcs		3/15/18	0.00	0.00	QC7-1		38
180	Small Fab	50 pcs		3/16/18	0.00	1.70	Small Fab-2		DAS
190	QC	50 pcs		3/16/18	0.00	0.00	QC5		38
200	Packaging	50 pcs		3/16/18	0.00	0.00	Packaging3-1	LG050	MAR 15 2018
210	QC21-SA	50 Ea		3/16/18	0.00	0.00	QC21		DAS

Part Op 100 - Cut blanks: 1.000" x 0.375" x 3.700" long

Descriptions: 110 - Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev ____ Folio Rev 9-80 MAR 15 2018

180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-043

200 - LOCATION : LG050

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	15.4150 ft (.3083 ea)	90-Start up Operation	
MS20426AD4-6	Rivet	300 Ea (6 ea)	180-Small Fab	F-M138621
MS21075L5	Nut Plate	150 Ea (3 ea)	180-Small Fab	5004858

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X1.000	15	43	0
180-Small Fab	MS20426AD4-6	300	1,320	0
	MS21075L5	150	374	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

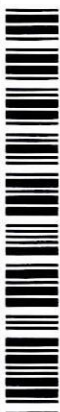
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐		Engineering Quality ☐ Other ☐	
Date :		MRB (QSI042) Approval									
Descriptive		Completed By									
		Lead hand / Supervisor Approval Verification									
		QC / QA Coordinator Approval									
Root Cause Environment ☐ No Re-vel ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Se ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Crushing ☐ Countersink ☐ Off-set ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐									
Date: 03/12/18 Container No: S050177 Part: D2873 - 043 Job No: 173681 Serial No/Batch: S050177 Revision: _____ Inspector: _____		s/ Surge ram ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐									
OTHER :											

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Email: sales@dartaero.com
www.dartaerospace.com



Container No: S050177



Part: D2873 - 043

Job No: 173681

Serial No/Batch: S050177

Revision: _____

Inspector: _____

DART AEROSPACE LTD		Work Order: 173681
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	✓		vern	man C-09
2.000	+/-0.010	2.000	✓			
0.750	+/-0.010	0.748	✓			
1.000	+/-0.010	1.002	✓			
0.250	+/-0.010	0.247	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	1.997	✓			
3.000	+/-0.010	3.002	✓			
Ø0.128	+0.005/-0.001	0.132	✓			
0.359	+/-0.010	0.358	✓			
Ø0.316	+0.006/-0.001	0.317	✓			
1.000	+/-0.010	0.998	✓			
0.250	+/-0.010	0.248	✓			
0.061	+/-0.010	0.067	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.230 x 0.121	✓			

Measured by: man L	Audited by: [Signature]	Prototype Approval:	N/A
Date: 18/03/11	Date: 18/03/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM	[Signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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